

Date: Friday, 7/4/2008 12:50:11 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FITTING  
 Job Number : 40301  
 Estimate Number : 10438  
 P.O. Number :  
 This Issue : 7/4/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : D32991  
 First Issue : / / Type : MACHINED PARTS Drawing Number : D3299 REV B  
 Previous Run : 38451 Material :  
 Due Date : 7/11/2008 Qty: 4 Um: Each  
 Written By :  
 Checked & Approved By : *[Signature]* 08 07 07  
 Comment : Est Rev: A 04.10.04 New issue KJ/JLM  
 Est Rev: B 07-06-11 Removed Manual Machining & Hex Bar  
 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B1250X01250 6061-T6 Bar 1.25 x 1.25"



Comment: Qty.: 0.2013 f(s)/Unit Total : 0.8051 f(s)

6061T6 BAR 1.250" X1.250"

Material: 6061-T6 (QQ-A-200/8 or QQ-A-225/8) 1.250"X1.250"

Batch: *M107744*

*J.F. 08/07/13*

(6)

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

Cut blank: 2.200" long

Turn as per Folio FA451 and Dwg D3299

*J.F. 08/07/13*

(6)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*J.F. 08/07/13*

(6)

4.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS

Machine as per Folio FA451 and Dwg D3299

CHAMFER PART USING CHAMFER MACHINE AS PER DWG D3299

Deburr

*ML 08/07/29*

(6)

5.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*ML 08/07/29*

(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 7/4/2008 12:50:11 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FITTING

Job Number: 40301

Part Number: D32991

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.L 08/07/31

7.0

OUTSIDE SERV.30

OUTSIDE SERVICES-MACH



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: 6865

Anodize as per Dwg D3299

Possible Supplier: TNM Paint

Material release note is required

C208/08/05

(6)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

C208/08/18

(6)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08-08-18 (6)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: B2

8/8/18

(6)

SP

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/2018

Job Completion



MF 08-08-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

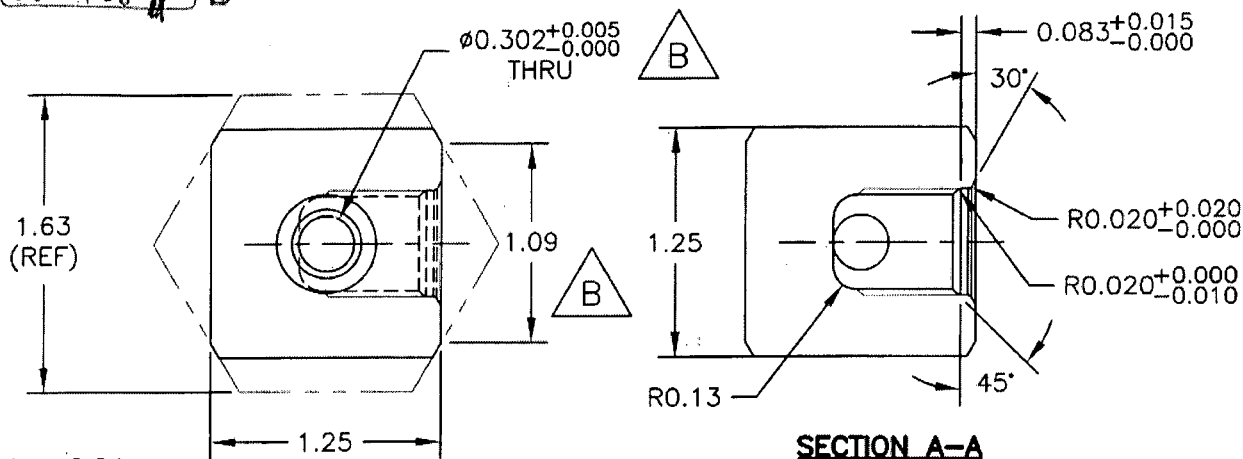
NOTE: Date & initial all entries



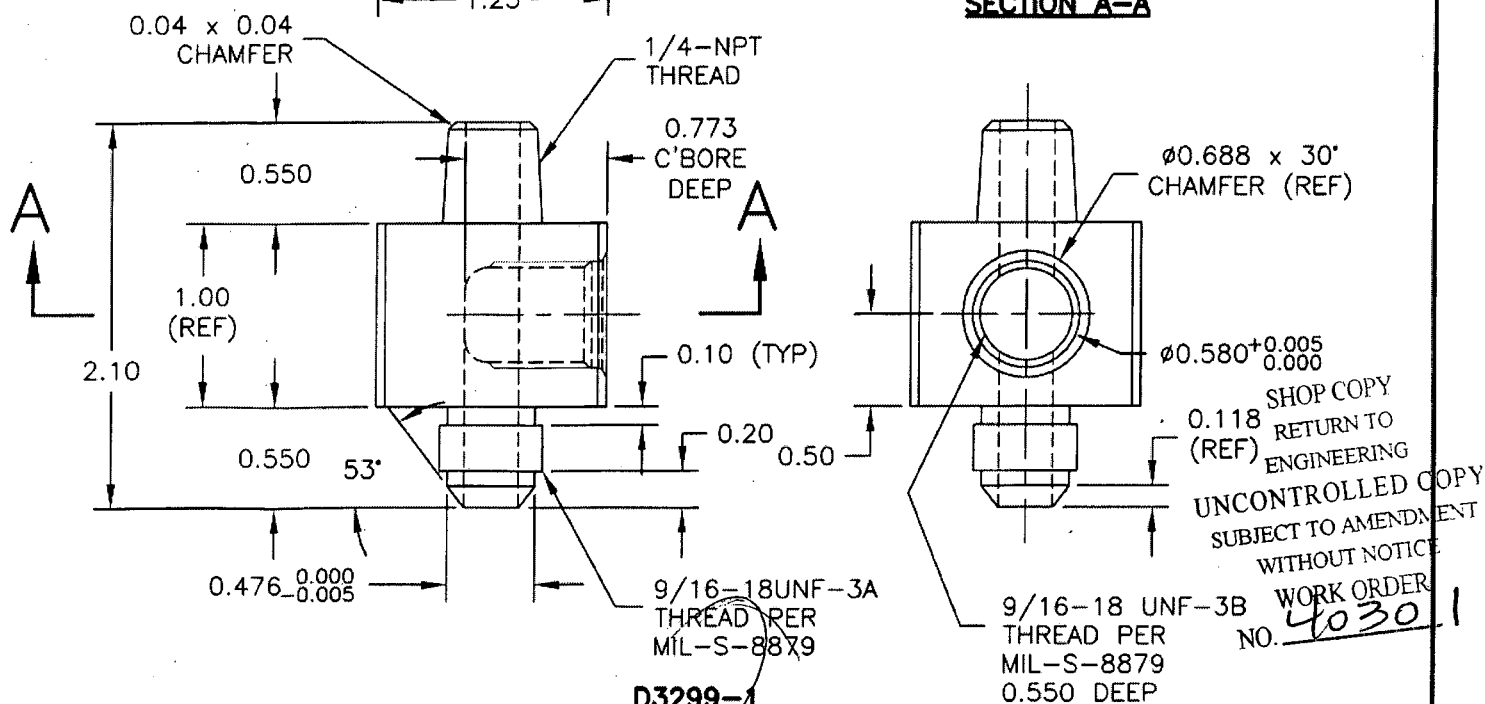


DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3299	REV. B SHEET 1 OF 3
DATE 05.04.28	TITLE FITTING	SCALE 1:1	
A	04.07.06	NEW ISSUE	
B	05.04.28	1.09 WAS 0.837; $\phi 0.302$ WAS $\phi 0.297$	

RELEASED  
05.04.28 #



SECTION A-A



D3299-1 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) 1.63 HEX BAR (M6061T6H1.625)
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2  
POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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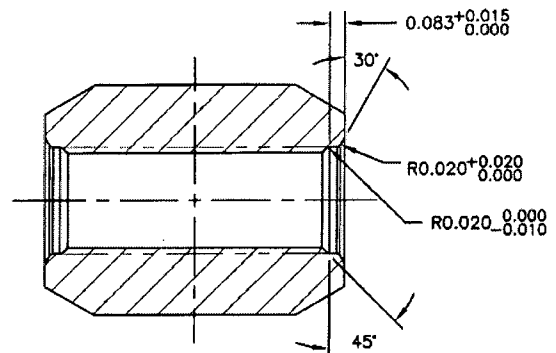
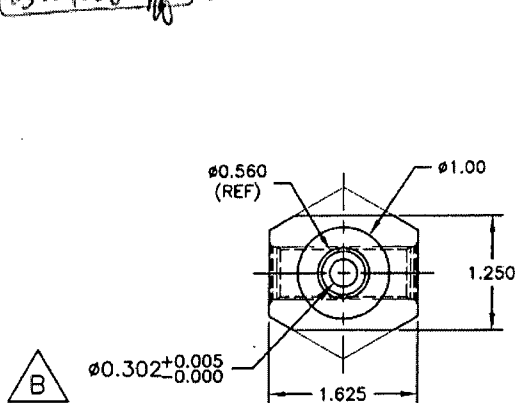
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NO. 40301

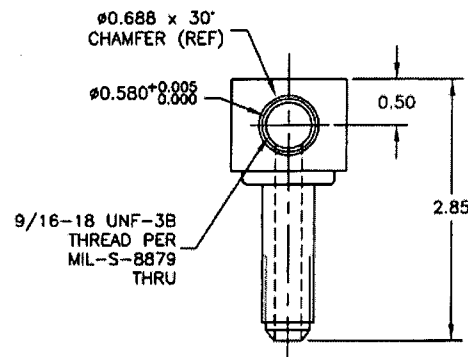
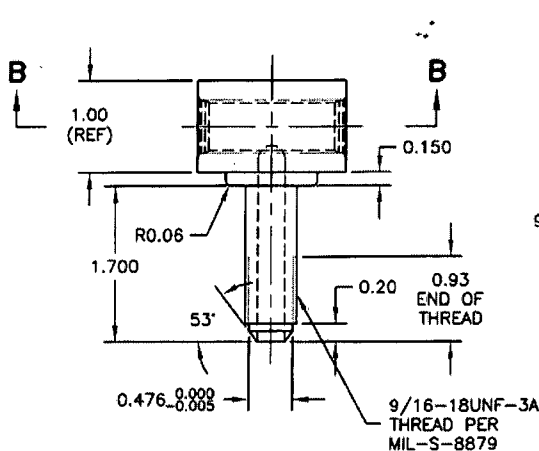


DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3299	REV. B SHEET 3 OF 3
DATE 05.04.28		TITLE FITTING	SCALE 1:2

RELEASED  
05.04.28



SECTION B-B  
SCALE 1:1



D3299-5

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WORK ORDER  
NO. 40301

D3299-5 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) 1.63 HEX BAR (M6061T6H1.625)
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2  
POSSIBLE SUPPLIER: ANODIZING TMM PAINT
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 certified  
approuvé NADCAP approved

67086

07-Aug-2008

CLIENT / CUSTOMER:

PART AEROSPACE LTD.

170 ABERDEEN STREET

BARKESBURY, ONTARIO

BA 1K7

CERTIFICATE OF COMPLIANCE  
CERTIFICAT DE CONFORMITENO. DE COMMANDE:  
PURCHASE ORDER/

PO00006865



ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION	PART PROCESS & TREATMENT
1	6	6	D3299-1 B40301	REV. B BLUE ANODIZE PER MIL-A-86251 TYPE II CLASS 2 ALL OVER
2	8	8	D3299-3 B40257	REV. B BLUE ANODIZE PER MIL-A-86251 TYPE II CLASS 2 ALL OVER
3	4	4	D3299-5 B40302	REV. B BLUE ANODIZE PER MIL-A-86251 TYPE II CLASS 2 ALL OVER

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.

Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

Parts are processed, tested, and inspected to the requirements of above specifications.

Travel cards have been filled and are available for viewing upon request.

NOTE: Painted Parts will be Fully Solvent Resistant after 7 (seven) Full Days of Air Curing at Ambient Temperatures

NOTE: Les pièces peintes seront complètement résistantes au solvant après 7 (sept) jours complets de séchage à l'air ambiant.

Signature/Signed:

Directeur de la Qualité / Q.A. Manager